Dart Aerospace Ltd.

Date: Thursday, 07/05/2009 2:41:10 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: CABIN FLOOR PROTECTOR
Job Number	: 47789		
Estimate Number	: 12661		
P.O. Number	:	**Part Number**	: D35742
This Issue	: 07/05/2009 **S.O. No.** :	**Drawing Number**	: D3574 REV.B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: B
Previous Run	: 46510	**Material**	:
Written By	:	**Due Date**	: 11/05/2009 **Qty:** 6 **Um:** Each
Checked & Approved By	: JL 09-05-07		
Comment	: Est Rev :A New Issue 07-01-22 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET

Comment: Qty.: 33.6000 sf(s)/Unit Total : 201.6000 sf(s)
lexan sheet
Batch: 111710 HB 9-5-12

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3574
Dwg Rev: B HB 9-5-12
Prog Rev: B

2-Deburr if necessary

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-5-12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK SD 09/05/13 (KG)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary. SD 09/05/13 (6)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 2:41:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** CABIN FLOOR PROTECTOR

Job Number: 47789 **Part Number:** D35742

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (40

7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock Location: PDP 47673

7/5/13

8.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion

MF
09-05-14

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47789
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-2
Inspection Dwg: D3574-2 Rev: B		Page 1 of 3

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+.012 -.001	3.009	X			
7.37	+/- .030	7.37	X			
10.75	+/- .030	10.75	X			
11.00	+/- .030	11.00	X			
15.25	+/- .030	15.25	X			
25.87	+/- .030	25.87	X			
39.75	+/- .030	39.75	X			
44.75	+/- .030	44.75	X			
53.51	+/- .030	53.51	X			
63.50	+/- .030	63.50	X			
65.25	+/- .030	65.25	X			
10.75	+/- .030	10.75	X			
11.00	+/- .030	11.00	X			
14.75	+/- .030	14.75	X			
25.50	+/- .030	25.50	X			
25.75	+/- .030	25.75	X			
26.00	+/- .030	26.00	X			
32.87	+/- .030	32.87	X			
38.81	+/- .030	38.81	X			
45.00	+/- .030	45.00	X			
48.25	+/- .030	48.25				
58.38	+/- .030	58.38				
61.25	+/- .030	61.25				

Measured by:		Audited by:		Prototype Approval:	
Date:	9-5-12	Date:	01/05/13	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	49789
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-2
Inspection Dwg: D3574-2 Rev: B		Page 2 of 3

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
64.13	+/- .030	64.13	*			
64.63	+/- .030	64.63	*			
66.50	+/- .030	66.50	*			
7.63	+/- .030	7.63	*			
11.00	+/- .030	11.00	*			
11.50	+/- .030	11.50	*			
16.75	+/- .030	16.75	*			
19.00	+/- .030	19.00	*			
22.50	+/- .030	22.50	*			
30.75	+/- .030	30.75	*			
32.63	+/- .030	32.63	*			
32.75	+/- .030	32.75	*			
35.13	+/- .030	35.13	*			
40.00	+/- .030	40.00	*			
41.88	+/- .030	41.88	*			
43.63	+/- .030	43.63	*			
7.50	+/- .030	7.50	*			
9.50	+/- .030	9.50	*			
10.38	+/- .030	10.38	*			
10.88	+/- .030	10.88	*			
14.50	+/- .030	14.50	*			
16.56	+/- .030	16.56	*			
18.75	+/- .030	18.75	*			

Measured by:	KB
Date:	9-5-13

Audited by:	S
Date:	09/05/13

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	47789
Description:	CABIN FLOOR PROTECTOR	Part Number:	D3574-2
Inspection Dwg: D3574-2	Rev: B		Page 3 of 3

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

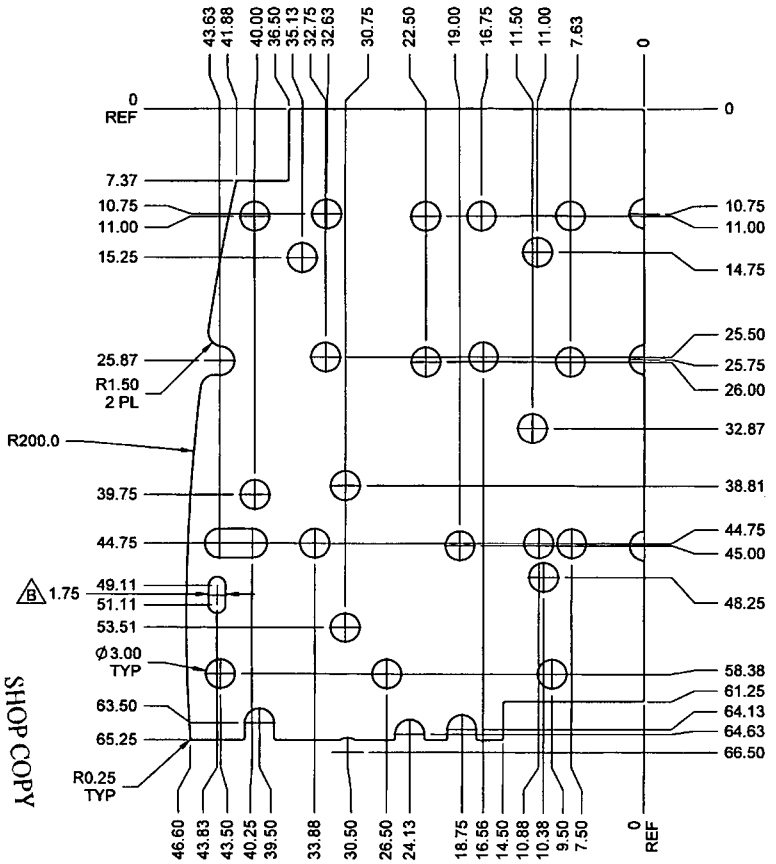
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.13	+/- .030	24.13	*			
26.50	+/- .030	26.50	*			
30.56	+/- .030	30.50	*			
33.88	+/- .030	33.88	*			
39.50	+/- .030	39.50	*			
40.25	+/- .030	40.25	*			
43.50	+/- .030	43.50	*			
46.60	+/- .030	46.60	*			
.125	+/- .010	.130	*			

Measured by:	JB
Date:	9-5-12

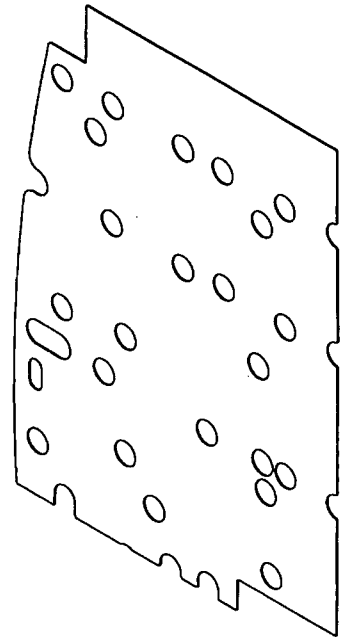
Audited by:	
Date:	09/05/13

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	







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D3574-1 CABIN FLOOR PROTECTOR

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.30 lbs
8) CHECK PER TEMPLATE DT8961

REV.	DESCRIPTION	BY	DATE
B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2		09.03.25
A	NEW ISSUE	CB	07.06.08

DESIGN	DART AEROSPACE LTD	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO. D3574	REV. B
MFG. APPR.		SHEET 1 OF 6
APPROVED	TITLE CABIN FLOOR PROTECTOR	SCALE NTS
DE APPR.		
DATE 09.03.25		

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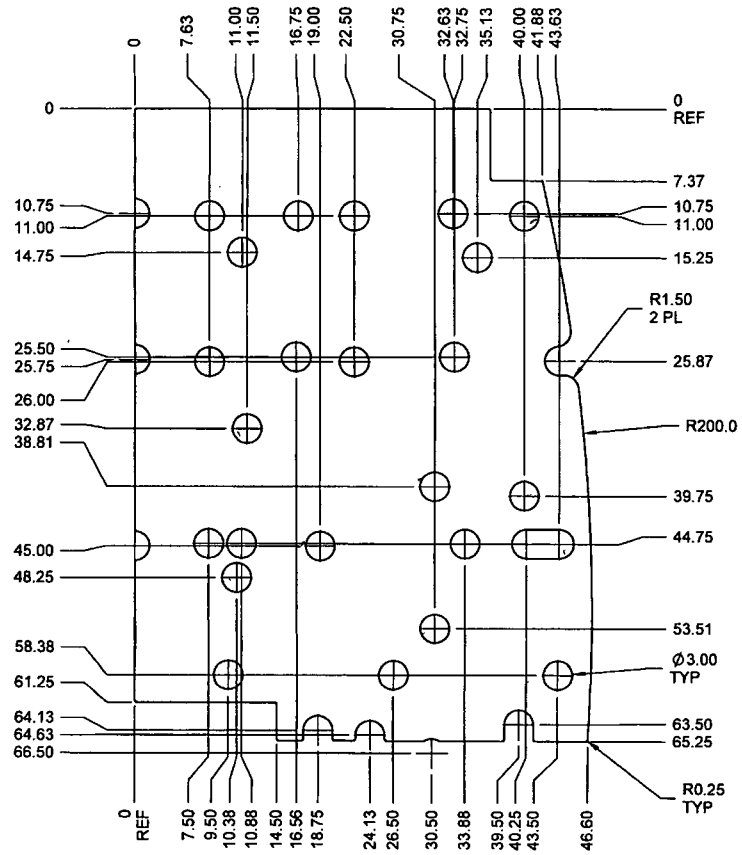
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

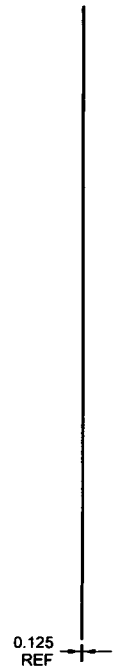
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

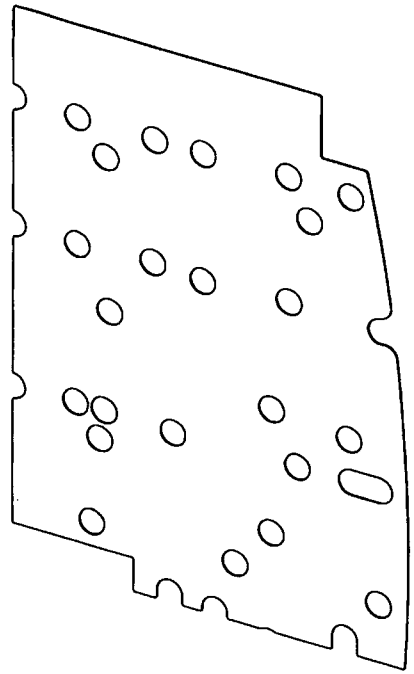
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries







D3574-2 CABIN FLOOR PROTECTOR

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NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.30 lbs
8) CHECK PER TEMPLATE DT8961

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3574 REV. B
MFG. APPR.		SHEET 2 OF 6
APPROVED		TITLE CABIN FLOOR PROTECTOR
DE APPR.		SCALE NTS
DATE 09.03.25		

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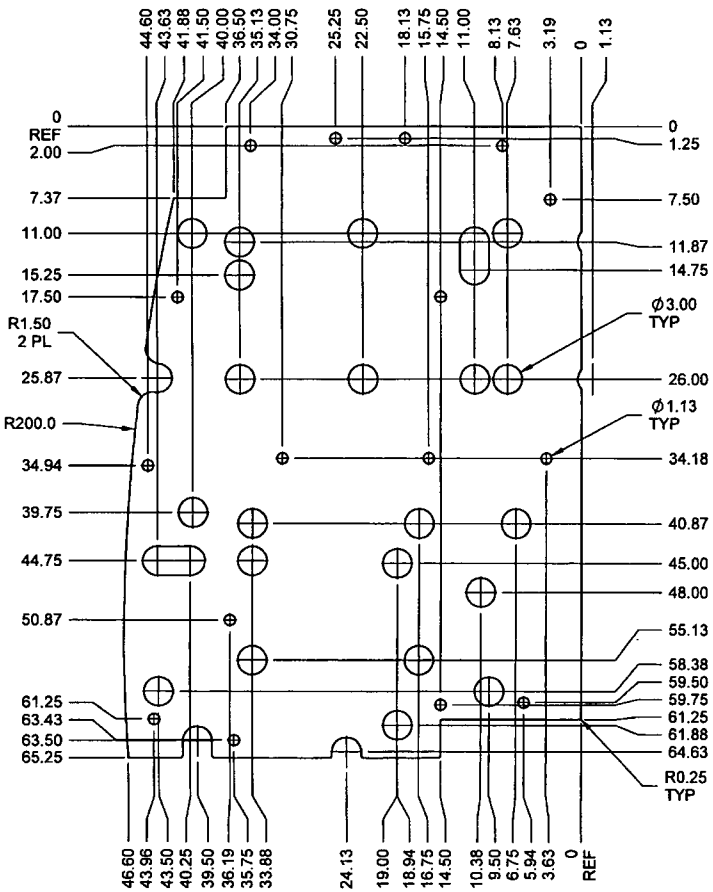
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

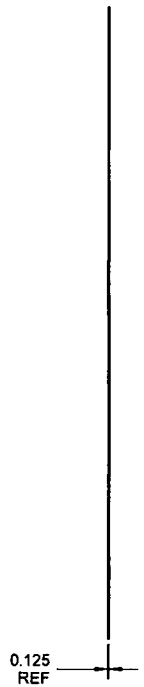
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

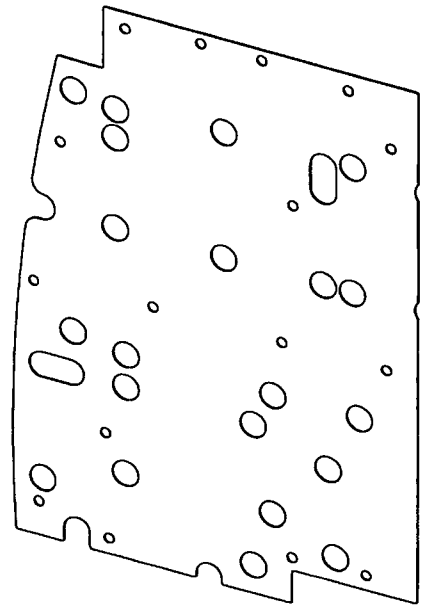
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries







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D3574-3 CABIN FLOOR PROTECTOR

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.33 lbs
8) CHECK PER TEMPLATE DT8962

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3574 — REV. B
MFG. APPR.		SHEET 3 OF 6
APPROVED		TITLE: CABIN FLOOR PROTECTOR — SCALE: NTS
DE APPR.		
DATE	09.03.25	

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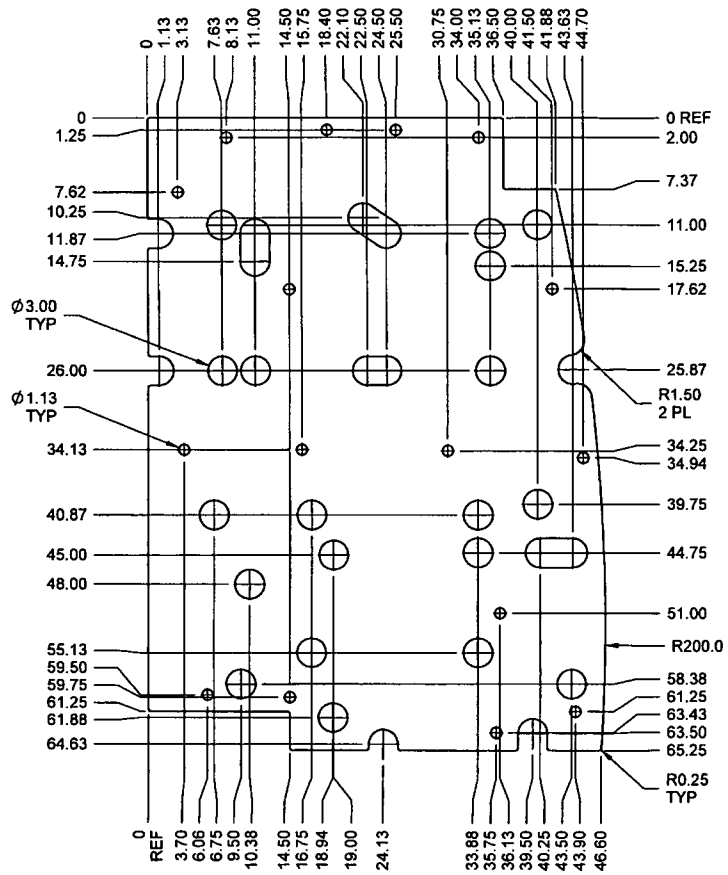
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

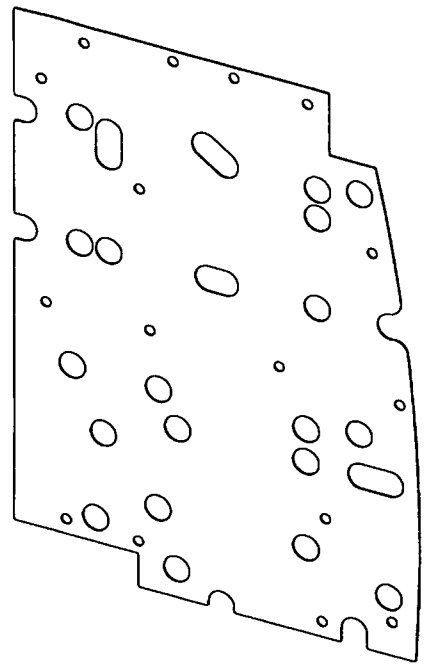
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries







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D3574-4 CABIN FLOOR PROTECTOR

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.18 lbs
8) CHECK PER TEMPLATE DT8963

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3574 REV. B SHEET 4 OF 6
MFG. APPR.		
APPROVED		TITLE CABIN FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE 09.03.25		

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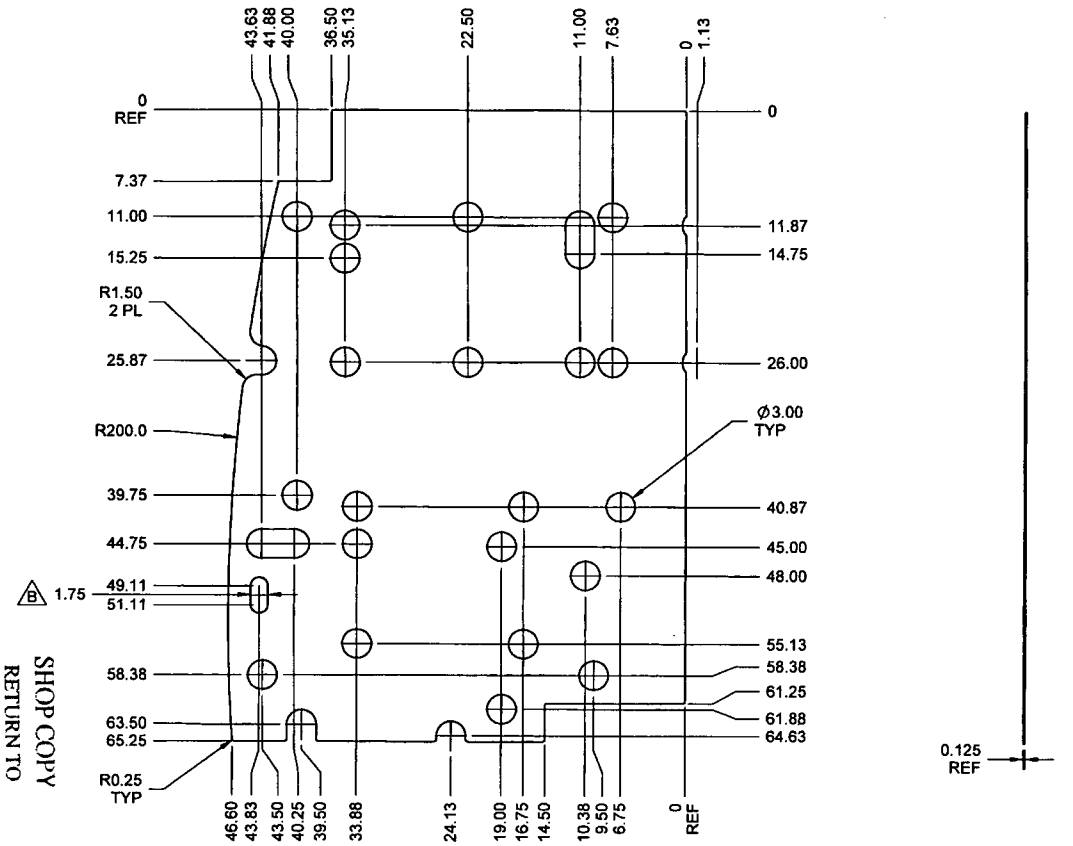
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

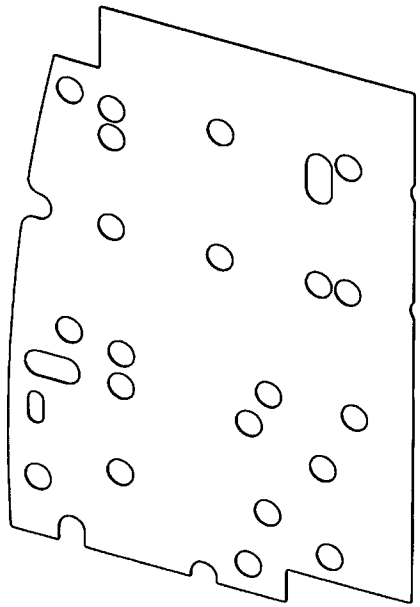
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries





D3574-5 CABIN FLOOR PROTECTOR

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NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.38 lbs
8) CHECK PER TEMPLATE DT8964

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3574 REV. B
MFG. APPR.		SHEET 5 OF 6
APPROVED		TITLE CABIN FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE 09.03.25		

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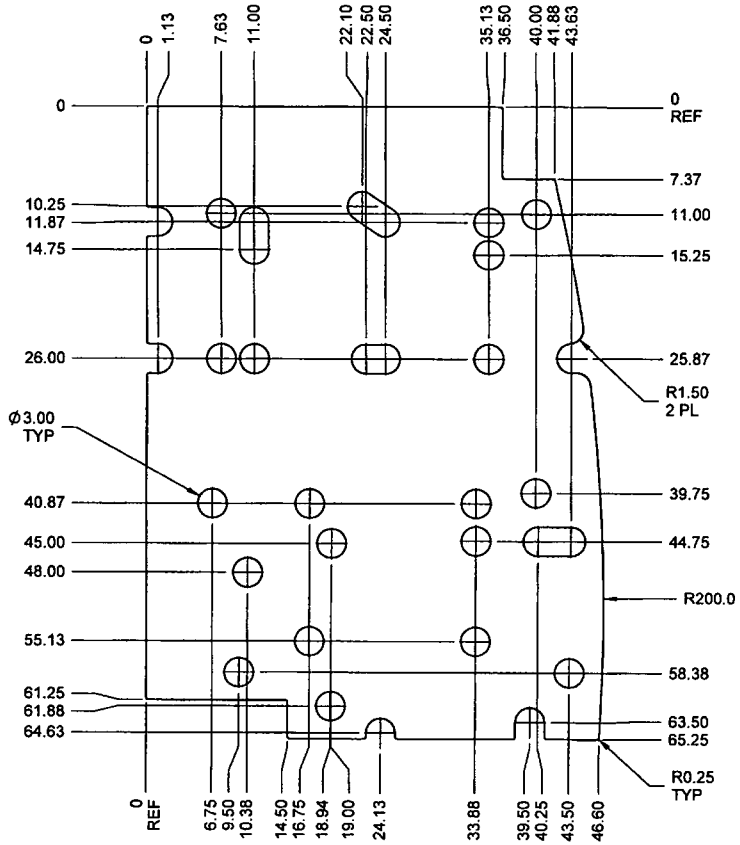
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

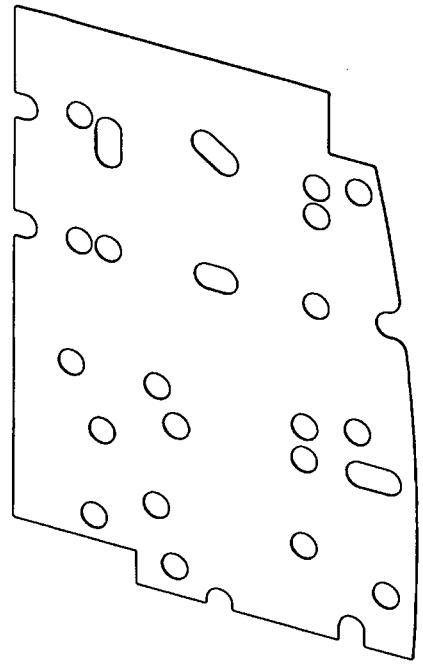
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3574-6 CABIN FLOOR PROTECTOR





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NO. B WORK ORDER

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
7) WEIGHT: 14.27 lbs
8) CHECK PER TEMPLATE DT8965

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3574 REV. B
MFG. APPR.		SHEET 6 OF 6
APPROVED		TITLE CABIN FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE 09.03.25		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries